

### Work Order ID 69508

Wednesday, May 11, 2011 1:56:10 PM



Page 1

Item ID: D3403-1 Accept Setup Start **Revision ID:** Stop Item Name: Bushing **Start Date: Start Oty: 100.00** 5/11/2011 **Cust Item ID:** Required Date: 5/12/2011 Reg'd Oty: 100.00 **Customer:** Reference: Run Start Date://\_05-// Tooling: Approvals: Process Plan: Date: Stop Date: \_\_\_\_\_ QC: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours** Code **Qty** Otv Number Stamp **Draw Nbr Revision Nbr** D3403  $\mathbf{C}$ 100 0.00 Hardinge CNC LATHE SMALL Hardinge 0.00 Memo Folio Rev: N Dwg Rev Hardinge CNC Lathe Small 1- Turn as per Folio FA556 & Dwg D3403 C\_□2-Deburr 11) 5/24 110 QC2- Inspect parts off machine FAI/FAIB 0.00 Memo Quality Control 120

Memo

RQ 11.5-25

Quality Control

QC8- Inspect parts - second check

0.00

Dart Aerospac	e Ltd
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W/O:			WORK ORDER CHANGES							
DATE	STEP	PROCEDURE	CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
		·								

Part No: _	PA	AR #: Faul	It Category	7=	NCR: Yes No	DQA:	Date:	
	Resolution:	Disp	osition: _		QA: N/C Closed	l:	Date:	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE STEP		Description of NC	Description of NC		Corrective Action Section B		Verification	Annuaval		
		Section A Init				Section C	Approval Chief Eng	Approval QC Inspector		
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						:	}			

### Work Order ID 69508

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Wednesday, May 11, 2011 1:56:10 PM

Item ID:

D3403-1

**Revision ID:** Item Name:

Bushing

**Start Date:** 

5/11/2011

**Start Qty: 100.00** Req'd Qty: 100.00

Date:

Accept

Setup Start

Stop



Reference:

Approvals:

Required Date: 5/12/2011

Process Plan:

QC:

Date:

**Tooling:** 

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Date:

Start Run

Stop

Sequence ID/ **Work Center ID** 

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location.

Memo

0.00

0.00

Tool ID

**Cust Item ID:** 

**Customer:** 

Tool # Plan

Accept Code Qty

Reject Qty

Reject Number

Insp. Stamp

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

V 1/208-25

W/O:		1		WORK ORDER	CHANGES				
DATE	STEP	PRO	CEDURE	CHANGE	Ву	/ (	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								i	
Part No	•	PAR #:	_ Fault	Category:	NCR: Y	es No	DQA:	Date:	
	R	esolution:	Disp	sition:	QA: N/0	C Clos	ed:	Date: _	
NCR:		W	ORK (	RDER NON-CON	IFORMANCE (N	ICR)			
DATE	STEP	Description of NC		Corrective Action			Verification	Approval	Approval
DAIL	O.L.	Section A	Initia Chief Er			gn & Date	Section C	Chief Eng	QC Inspector
									* 
		:							

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# **Picklist Print**

Wednesday, May 11, 2011 1:56:18 PM

Work Order ID: 69508

Parent Item:

D3403-1

Parent Item Name: Bushing



Start Date: 5/11/2011

Required Date: 5/12/2011

Page 1

**Start Qty: 100.00** 

Required Qty: 100.00

Comments:

IPP Rev:A□05.08.31□New issue□KJ/JLM IPP Rev:B 06-03-07 As per Rev B JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.750		Purchased	No		100	f	119.5500	0.208	20.8			-
									15	10	(5/2)	
303 Round Bar 0.750										<b>\</b> \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	4/00	J

<b>Location</b>	Loc Qty	Loc Code	
- MAT028	119.55		
117142	17.55		<u> 17 PF</u>
117328	49		- A.
<del>-</del> 117481	53		_3 #x

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W/O:				WORK ORDER CHANGES						
DATE	STEP	PRC	CEDURE	CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		*								
Part No		PAR #:	1							
	R	esolution:	Dispo	sition:	QA: N/C (	losed:		Date: _		
NCR:	:	V	VORK O	RDER NON-CONFORM	MANCE (NC	R)				
DATE	STEP	Description of NC Section A	Initial	Action Description	ection B Sign	& Secti	cation on C	Approval Chief Eng	Approval QC Inspector	
			Chief En	Chief Eng	Date	)	· · · · · · · · · · · · · · · · · · ·			

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DART AEROSPACE LTD	Work Order:	69508
Description: Bushing	Part Number:	D3403-1
Inspection Dwg: D3403 Rev: C		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.416	+0.010/-0.000	2.422			21-6	
0.060	+/-0.005	062				
Ø0.257	+0.010/-0.000	1.258				·
Ø0.750	+/-0.010	1,750				
Ø0.425	+0.000/-0.002	1,424			sh-5	·
0.030 x 20°	+/-0.010	0301200				
Ø0.313 x 60°	+/-0.010	A.3/3×60				
	_					

		<u>.                                    </u>			
Measured by:	27	Audited by:	Ť	Preliminary Approval:	
Date:	11)5/24	Date: ( (	.5.25	Date:	

Rev	Date	Change	Revised by	Approved
Α	06.04.21	New Issue	KJ/JLM 1	
В	10.11.17	Dimensions updated per Dwg Rev C	KJ de-	$\square$
			1/1	,

Dart Aerospace Lt
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W/O:		WORK ORDER CHANGES									
DATE STEP		PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
					1				7 Tod Mgi		
							•				
Part No:		PAR #:	Fault Cate	NCR: Yes No DQA: Date:							
	Res	solution:	Disposition	on:		QA: N/C	losed:		Date: _		
NCR:			WORK ORD	ER NON-CONF	ORMAN	ICE (NC	R)				
		Description of NC	Corrective Action		Section B		Verif	cation	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Descr Chief Eng		Sign Date	&   Sec	tion C	Chief Eng	QC Inspector	
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SHOPCOPY RETURN TO ENGINEERING **UNCONTROLLED COPY** Ø0.313 X 60° Ø0.750 0.060±0.005 CSINK SUBJECT TO AMENDMENT WITHOUT NOTICE Ø0.425<sup>+0.000</sup> Ø0.257<sup>+0.010</sup> 0.030 X 20° CHAMFER R0.010 TYP **SECTION A-A D3403-X BUSHING** DART P/N WEIGHT (ibs) D3403-1 2,416 0.07\_\_\_ D3403-3 2.165 0.06 D3403-5 2.500 0,07 REFORMAT TO CURRENT STD PER QSI 043; ADDED мв 10.04.21 D3403-5. TOL WAS +0.005/-0.000, REASON: PAR#10-029 ADD COUNTERSINK PH 06.01.23 Α NEW ISSUE PH 05.03.07 REV. DESCRIPTION BY 1) MATERIAL: AISI 303 SS ROUND BAR PER ASTM A582 DATE DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA REF. DART SPEC, M303R DRAWN 2) FINISH: NONE CHECKED DRAWING NO. REV. C 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED MFG. APPR. D3403 SHEET 1 OF 1 4) UNITS: INCHES UNLESS OTHERWISE NOTED APPROVED TITLE 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE SCALE DE APPR. BUSHING 7) WEIGHT: PER TABLE DATE COPYRIGHT © 2005 BY DART AEROSPACE LTD 10.04.21

Dart Ae	rospace	: Ltd						•	
W/O:				WORK ORDER	CHANGES				
DATE	STEP		PROCEDURE	CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•		PAR #: Fault	Category:	NCR: Yes	s No <b>DQ</b>	A:	Date: _	<del></del>
	R	esolution:	Dispo	sition:	QA: N/C	Closed:		Date: _	
NCR: WORK O			RDER NON-CONFORMANCE (NCR)						

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE STEP		Description of NC Section A Initia Chief E		Corrective Action  Action Description  Chief Eng	Verification Section C	Approval Chief Eng	Approval QC Inspector			
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